Work Order ID 126798 Page 1 Wednesday, November 26, 2014 7:23:23 AM Accept Setup Start \*N900040100\* Cargo Floor Protector Start Qty: 1.00 **Cust Item ID:** Req'd Qty: 1.00 **Customer:** Run Process Plan: MCS Date: 14-11-26 Tooling: Date: Stop QC: \_\_\_\_\_ Date: SPC (Y/N): Date: **Operation** Set Up/ **Tool ID** Tool # Plan Reject Reject Accept Insp. Description Code Qty **Qty** Number Stamp **Run Hours** Revision Nbr 0.00 FLOW WATER JET 0.00 Memo 1-Cut as per Dwg D3575 Dwg Rev: A Prog Rev: A 2-Deburr if necessary

110

Item ID:

**Revision ID:** 

Item Name:

**Start Date:** 

Reference:

**Approvals:** 

Sequence ID/

Draw Nbr

D3575

\*100\* Waterjet

FLOW CNC Waterjet

100

**Work Center ID** 

**Required Date:** 11/26/2014

D3575-6

11/26/2014

Rev A

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

NOV 27 2014

DAS

0 2/02/4/11/26

DQA:			Date:			WORK OPDER NON	DER NON-CONFORMANCE / UPDATE							
QA Closed:			Date:			WORK ORDER NON		JINFOR	MVIAINCE / C		ork Order up	date only	AEROSPACE	
Work Orde	er:					DISPOSITION								
Part No  NCR No  Root Desc				Rework Scrap Use-as-is Suspected Unapproved		ا Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other			
Root					Desci	ription of work order update	ı	nitial	A	ction	Sign &			
Cause	ŀ	Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription	Date	Verification	n QC Inspector	
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
					• • • • • • • • • • • • • • • • • • • •		FA	ULT CAT	EGORY					
Landi	ng Ge	ear				General	FA	OLI CAI	EGORT					
		Bending Centre No Cracks Crimp/Kir Cuffs Crushing				Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink		Grain Hardwa Inspecti Instruct	on Incomplete/lions Incomplete	/Unclear	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled	
$i^{*}n^{*}$		Heat Trea nspection		Tube		Cut Too Short Drawing	-	Mislabe Misreac			Positioned V Power Loss/	· ·	Other	
		Marks/Ch	atter	-		Drill Holes		Off-set						
	_	Furning So Wave/Tw		oe		Finish Fit/Function		1	Calibration Sequence					

0.00

DAS

66

9-89

Identify as per dwg & Stock Location:

Memo

150

\*150\*

Packaging

Packaging

DQA:			Date:			WORK OBDED NON	c	אוב הי	DNAANCE / II	IDDATE			DART
QA Closed:			Date:			WORK ORDER NON	-((	JINFUR	RIVIAINCE / U		ork Order up	date only	AEROSPACE
Work Orde	or.					DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No  NCR No  Root Des					Rework Scrap Use-as-is Suspected Unapproved		1 Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Desc	ription of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	ı	ief Eng		ription	Date	Verification	n QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
							FAI	ULT CAT	EGORY		<del> </del>		
Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence			General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set			Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other			
			equence ist in Tub	ie		Fit/Function	-	Out of Calibration Out of Sequence					

Work Order ID 126798 Page 3 Wednesday, November 26, 2014 7:23:23 AM Item ID: D3575-6 Accept \*N900040100\* Setup Start **Revision ID:** Cargo Floor Protector Item Name: 11/26/2014 Start Qty: 1.00 **Start Date: Cust Item ID: Required Date:** 11/26/2014 **Req'd Qty:** 1.00 **Customer:** Reference: Run Process Plan: Approvals: Date: \_\_\_\_\_ **Tooling:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Tool ID Operation Reject Set Up/ Tool # Plan Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp QC21- Final Inspection - Work Order Release 160 0.00 \*160\* QC 0.00 Memo

Quality Control

F\_\_\_\_\_

DQA: Date:			DART										
0.0						WORK ORDER NON-	-CC	ONFO	RMANCE / U				AEROSPACE
QA Closed:			Date:	· · · · · · · · · · · · · · · · · · ·		· · · · · · · · · · · · · · · · · · ·					ork Order up	date only	
Work Orde	er:					DISPOSITION		-		AGAINST D	EPARTMENT		
					_	Rework		Skid-tube Crosstub			Water Jet		Engineering
Part N	No.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is			noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR No.				Suspected Unapproved			Large Fab	Composite		Supplier			
Doot					0	······				<b></b>	Cian 0	# ·.	
Root		Data	Cham	O4	Descr	ription of work order update	l	nitial		ction	Sign &	Varification	OC Inspector
Cause		Date	Step	Qty		or non-conformance	Cn	ief Eng	Desc	cription	Date	Verification	QC Inspector
Design	H						İ						
Doc/Data													
Equip/Tooling	$\vdash$												
Handling/Pre	-												
Material Operator						·							
Offset/Setup	Н												
Process	$\vdash$												
Supplier	Н												
Training	$\Box$												
Transport	$\square$												
Unapproved													
			· · · · · · · · · · · · · · · · · · ·				FAI	ULT CAT	TEGORY				
Landii	ng Ge	ar		<del></del>		General							
	В	ending				Bend		Folio/P	rogram	Ţ.	Outside Dim	ensions	Pressure/Forced
		entre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	C	racks				Broken/Damage/Defect		Hardwa	re		Part Incorred	it	Temperature/Cure
	C	rimp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	Jnqualified	Part Lost/Mi	ssing	Weld
•		uffs				Contamination		Instruct	ions Incomplete/	/Unclear	Part Moved		Wrong Stock Pulled
	C	rushing				Countersink		Misalig	ned/off center		Positioned V		_
	Шн	eat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	∐lr	spection	Strip in	Tube		Drawing		Misread	t		-,-,		
	Ш∾	1arks/Ch	atter			Drill Holes		Off-set					
	ا ا	urning Se	equence			Finish		Out of (	Calibration				
	v	/ave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Picklist Print

Wednesday, November 26, 2014 7:23:29 AM

Work Order ID: 126798

\*126798\*

Parent Item:

D3575-6

\*D3575-6\*

Parent Item Name: Cargo Floor Protector

Start Date: 11/26/2014

Required Date: 11/26/2014

Page 1

Start Qty: 1.00

10.666

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12

Required Qty: 1.00

**Comments:** 

IPP Rev : A New Issue 07.07.23

Purchased

verified by:JLM

No

										···			
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status

GE PLASTICS LEXAN SHEET

MLEXS.125-F60029-04

cation	Loc Oty	Los Codo

100

<b>Location</b>	Loc Qty	Loc Code		
MAT019	2158.68738			
124866	106			
m126425	160.925			
m127934	665			
m12 <u>874</u> 6	80.505			
m129759	1146.25738		**************************************	16.666
SABIC	2560			
m130209	2560			

sf

4,718.687

DQA:			Date:			. WORK ORDER NON	ORDER NON-CONFORMANCE / UPDATE						
QA Closed:			Date:			WORK ORDER NON		JINFOI	NVIAINCE 7 C		ork Order up	odate only	AEROSPACE
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No.  NCR No.  Root Des					Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Desci	ription of work order update		nitial	Ac	ction	Sign &		
Cause	1	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
							FAI	ULT CAT	EGORY				
Landi		ear Bending				<b>General</b> Bend			rogram	Γ	Outside Dim	ensions [	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain	3	<u> </u>	Over/Under	tolerance	Set-up
		Cracks Crimp/Kin				Broken/Damage/Defect Burrs		Hardwa	re on Incomplete/U	Inqualified	Part Incorred	et [	Temperature/Cure Weld
	_	Cuffs	mppie	, ***		Contamination	-	1	ions Incomplete/	· —	Part Moved	· · ·	Wrong Stock Pulled
	_	Crushing				Countersink		1	ned/off center	<del></del>	Positioned V	L	
	-	Heat Trea	t			Cut Too Short		Mislabe			Power Loss/	· ·	Other
	-	Inspection		Tube		Drawing		Misread		<u> </u>			1-300
	_	Marks/Ch				Drill Holes	-	Off-set	-				
	-	Turning S				Finish		4	Calibration				
		Wave/Tw				Fit/Function	Out of Sequence						

DART AEROSPACE LTD	Work Order:	126798
Description: Cabin Floor Protector	Part Number:	D3575-6
Inspection Dwg: D3575 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	Ø 3.ec			Tone	
3.38	+/-0.030	3.38	/		V=De 02	
6.50	+/-0.030	6.50			10 - 17 - 50-	
26.13	+/-0.030	26.13				
30.13	+/-0.030	30./3	_			
2.00	+/-0.030	2.00	_			
3.50	+/-0.030	3.50	_			
14.25	+/-0.030	14. 25	/			
25.13	+/-0.030	25.13				
29.38	+/-0.030	29.38	_			
30.38	+/-0.030	30.38	_			
31.50	+/-0.030	31.50	J			
1.00	+/-0.030	1.00	<i></i>			
4.38	+/-0.030	4.38				
14.50	+/-0.030	14.50	_			
16.00	+/-0.030	16.00	_			
23.13	+/-0.030	23.13	/			
26.88	+/-0.030	26.88	/			
27.69	+/-0.030	27.67	~			
1.00	+/-0.030	/				
		1.00				
3.75	+/-0.030	3.75				
9.63	+/-0.030	9,63				
16.13	+/-0.030	16.13	<i>-</i>			
28.06	+/-0.030	28,00				
32.15	+/-0.030	32-15	DAS			

Measured by: Defe Audited by: 9-89 Prototype Approval: N/A

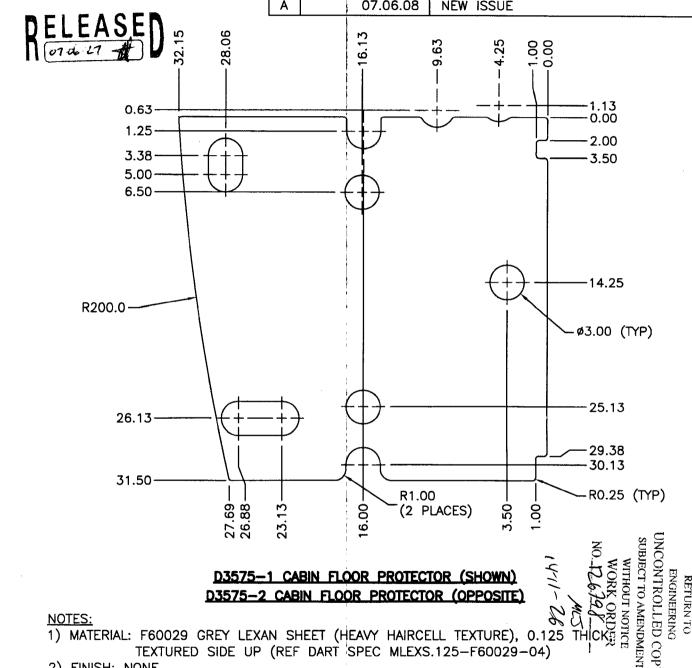
Date: 14/11/26 Date: NOV 2 7 2014 Date: N/A

A 08 01 16 New Issue   KJ//DD	- 1	Rev	Date	Change	Revised by	
/		Α	08.01.16	New Issue	· · · · · · · · · · · · · · · · · · ·	

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DESIG	<u>'</u>	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHEC	ED .	APPROVED #	D3575	REV. A SHEET 1 OF 4				
DATE			TITLE	SCALE				
07.0	6.08		CABIN FLOOR PROTECTOR	1:8				
	-	07.00.00	MEM TOOME					



D3575-1 CABIN FLOOR PROTECTOR (SHOWN) D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE

- NOTES:

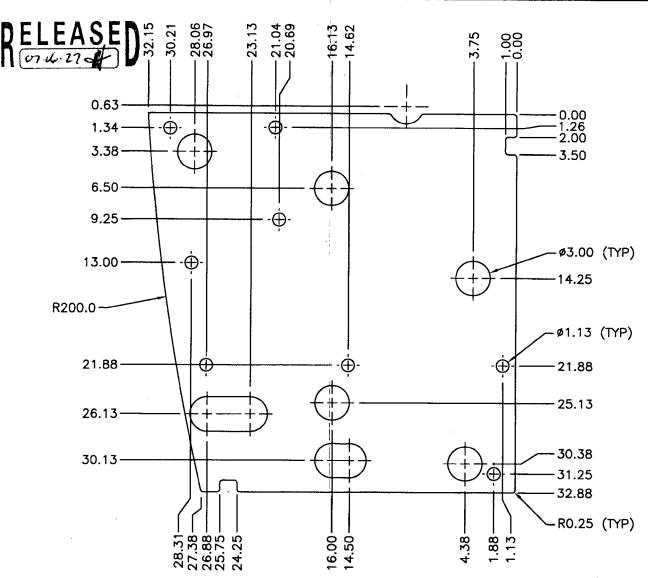
  1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICKE TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

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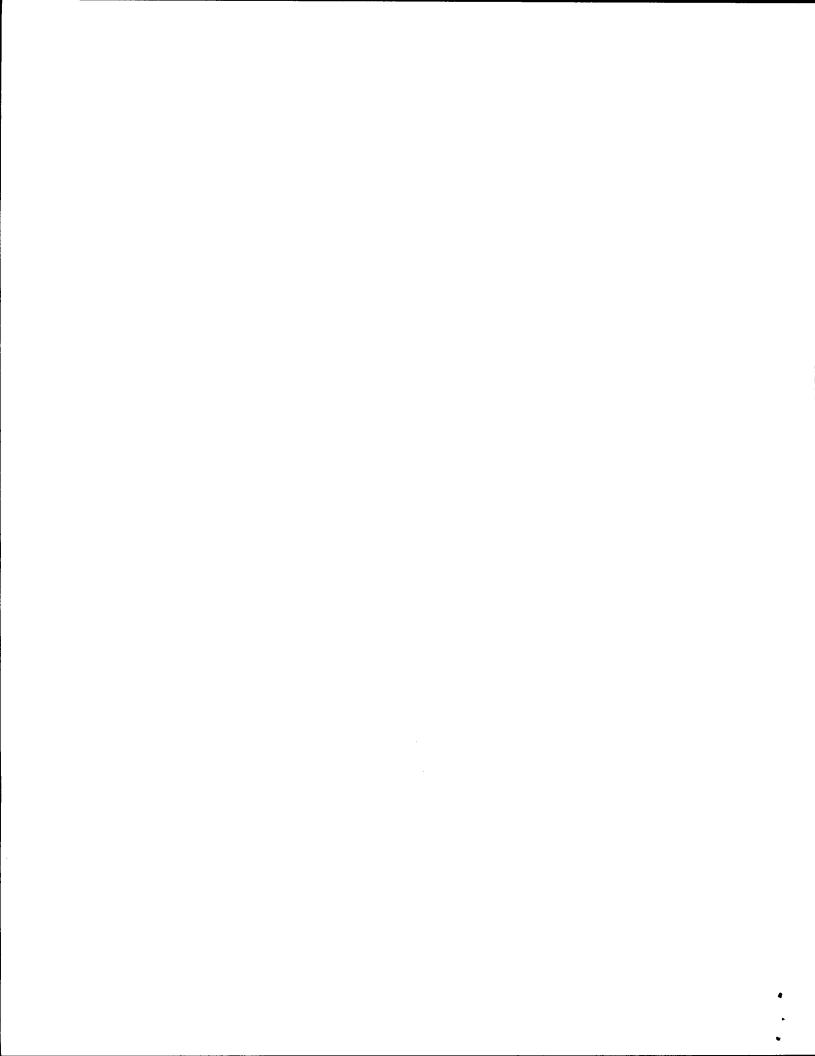
## D3575-3 CABIN FLOOR PROTECTOR

#### NOTES:

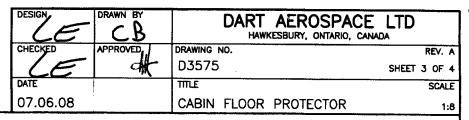
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

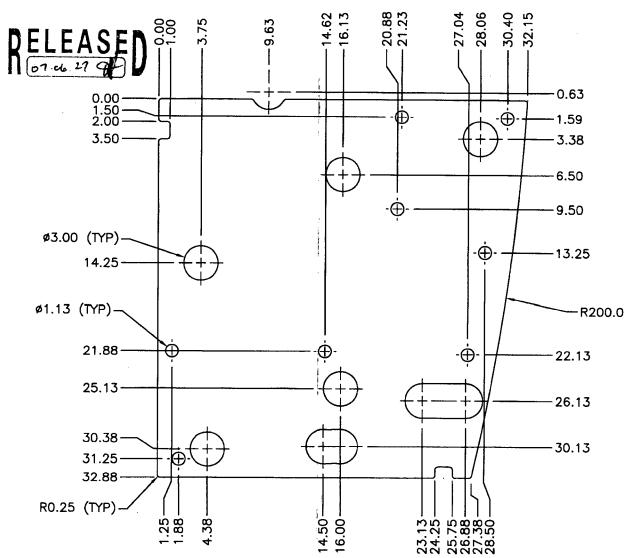
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## D3575-4 CABIN FLOOR PROTECTOR

### NOTES:

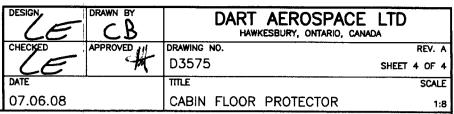
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

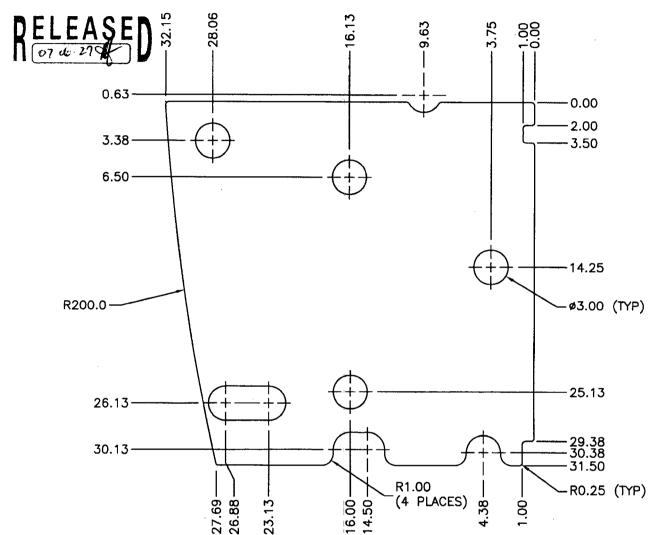
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# D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART, SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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